

Date: Thursday, 11/23/2006 11:53:13 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 29662		
Estimate Number	: 10533	Part Number	: D2573
P.O. Number	: N/A	Drawing Number	: D2573 REV E
This Issue	: 11/23/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: E
First Issue	: N/A Type : MACHINED PARTS	Material	: N/A
Previous Run	: 29512	Due Date	: 12/20/2006 Qty: 12 Um: Each
Written By	: <u>[Signature]</u>		
Checked & Approved By	: <u>06 11 23</u>		
Comment	: Est: I AS Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B25353

06/12/11

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 29662 Double check by: 06/12/09

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per

Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

06/12/12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

06/12/12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/12/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/12/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:53:13 AM
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Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/12/14

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

am/sr

(13)

7.0

POWDER COATING

POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L / M.M 06/12/20 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M 06 12 20

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57474

06/12/21

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/22

Job Completion



06/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

403

DART AEROSPACE LTD	Work Order:	29662
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.446	0.440	0.440	0.448		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.506	3.506	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.508	0.504	0.503	0.498		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.376	0.377	0.377		
I	0.490	0.510		0.501	0.502	0.502	0.501		
J	1.174	1.184		1.179	1.179	1.178	1.175		
K	0.558	0.578		0.567	0.568	0.567	0.566		
L	1.174	1.184		1.179	1.179	1.178	1.175		
M	1.365	1.375		1.370	1.376	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.121	4.121	4.121	4.124		
P	0.115	0.135		0.127	0.128	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	0.250		
S	0.115	0.135		0.134	0.132	0.129	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.246	0.240	0.240	0.240		
W	0.115	0.135		0.133	0.133	0.133	0.129		
X	0.308	0.313		0.316	0.316	0.316	0.311		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.366	0.364	0.364	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.634	0.634	0.629	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.245	0.248	0.248		
AE	1.500	1.520		1.511	1.513	1.509	1.513		
AF	0.115	0.135		0.129	0.122	0.122	0.122		
AG	0.240	0.280		0.268	0.260	0.268	0.263		
AH	0.240	0.260		0.249	0.250	0.250	0.249		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	MDJ
Date:	06/12/11

Audited by:	En
Date:	06/12/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	29662
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Inspection Dwg: D2573 Rev. E		Page 1 of 1

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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.498	.495	.498		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.501	.500	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.566	.568	.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.122	4.122	4.123		
P	0.115	0.135		.127	.126	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.125	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.239	.240		
W	0.115	0.135		.127	.130	.129	.129		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.761	.762	.762	.762		
Z	0.352	0.372		.364	.364	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.628	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.25		
AE	1.500	1.520		1.512	1.512	1.512	1.512		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.248	.248	.248	.248		
AI	2.000	2.020		2.002	2.001	2.005	2.001		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by:	SA
Date:	06.12.12

Audited by:	En
Date:	06.12.14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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C	3.495	3.505		3.505	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.751		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		.501	0.504	0.502	0.505		
G	0.257	0.262	DT8683	.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	.376	0.376	0.376	0.376		
I	0.490	0.510		.490	0.501	0.501	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	0.568	0.567	0.567		
L	1.174	1.184		1.175	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
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S	0.115	0.135		.126	0.132	0.132	0.129		
T	0.178	0.198		.188	.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.238	0.246	0.241	0.240		
W	0.115	0.135		.126	0.133	0.133	0.133		
X	0.308	0.313		0.311	0.311	0.310	0.310		
Y	0.760	0.765		0.762	0.760	0.760	0.760		
Z	0.352	0.372		.365	0.364	0.365	0.364		
AA	0.470	0.530		.500	.500	0.500	0.500		
AB	0.615	0.635		.627	0.628	0.629	0.625		
AC	0.053	0.073		.063	.063	0.063	0.063		
AD	0.240	0.260		.250	0.246	0.247	0.248		
AE	1.500	1.520		1.512	1.512	1.512	1.510		
AF	0.115	0.135		.135	.135	.135	0.125		
AG	0.240	0.280		.265	.265	.265	0.260		
AH	0.240	0.260		.248	0.249	0.250	0.250		
AI	2.000	2.020		2.001	2.001	2.001	2.001		
AJ	0.023	0.043		.030					
Accept/Reject									

Measured by:	SA / 9m2
Date:	06.12.13 / 06/12/14

Audited by:	Er
Date:	06/12/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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05.12.06

2:

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WORK ORDER
NO. *24662*